

Date: Wednesday, 3/7/2007 8:35:02 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE ASSEMBLY
Job Number : 31025	
Estimate Number : 12631	
P.O. Number : <i>N/A</i>	Part Number : D2127251905 ✓
This Issue : 3/7/2007 S.O. No. : <i>N/A</i>	Drawing Number : D212-725-1 REV <i>A B A</i>
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : 3/6/2007 Type : SMALL /MED FAB	Drawing Revision : <i>X B A</i>
Previous Run : 30204	Material : <i>N/A</i>
Written By : _____	Due Date : 3/13/2007 Qty: 4 Um: Each
Checked & Approved By : <i>JA 07.03.07</i>	
Comment : Est Rev:A New Issue 07-01-08 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1:0	M304TR1000WO49	304 RD Tube 1.0" x .049W
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Comment: Qty.: 3.1500 f(s)/Unit Total : 12.6000 f(s)

304 RD Seamless Tube 1.0" x .049W

Batch: *M103841 / M163841**FF 07-03-26*

4

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form as per Dwg D212-725-1 & Template DT8907

FF 07-03-26

4

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

07/03/26 (3)

4

4.0	MS2081916J	Sleeve
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Sleeve

Batch: *M103249**FF 07-03-26*

4

5.0	AN81816J	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

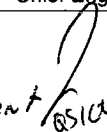

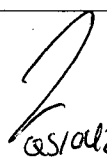

Nut

Batch: *M1256x1 - M17123x5 - M103177x2**FF 07-03-26*

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/26	2	Tube assembly short one end. Replace Take measurement From drawing instead of template / pieces (Trail pieces)		Destroy & Replace	FF 07/03/26	 07/03/26	 05/04/2	 07/03/26

NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 31025

Part Number: D2127251905

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Flare and Install Sleeves & Nut as per Dwg D212-725-1.

FF 07-04-02

4

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/12 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/04/13 (4)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/16

Job Completion



U 07-04-16

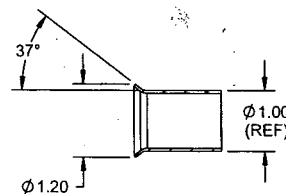
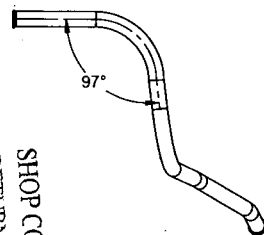
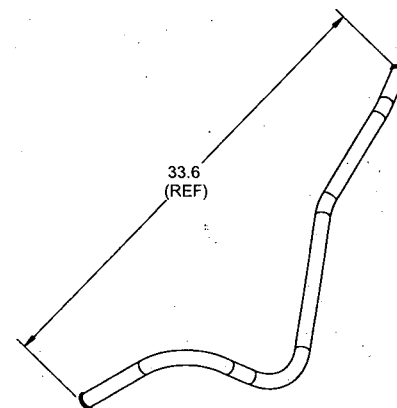
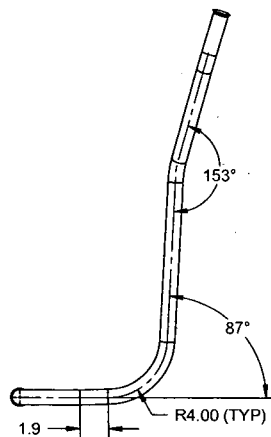
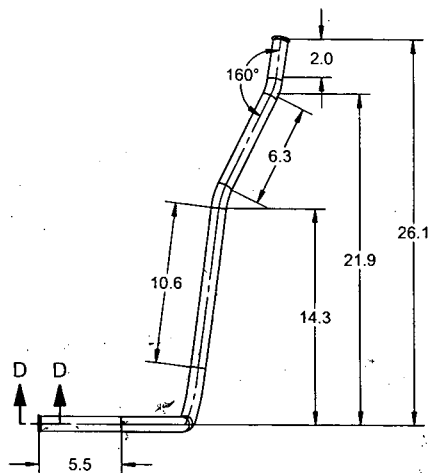
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

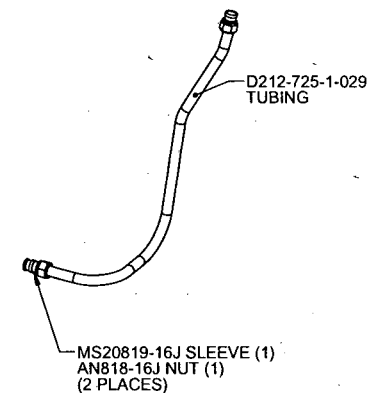
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION D-D
(FINISH FLARE ONE END
AFTER ASSEMBLY)
SCALE 1 : 2
(2 PLACES)



D212-725-1-905 TUBE ASSEMBLY

D212-725-1-029 TUBING
MANUFACTURE PER TEMPLATE DT8907

NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL 1.00 O.D. x 0.049 WALL
(REF. DART SPEC. M304TR1.000W.049)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY ASSEMBLY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31025

DESIGN DC	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED	DRAWING NO. D212-725-1	REV. A SHEET 10 OF 37
DATE 06.12.08		TITLE 212S DETAIL PARTS	SCALE 1:8
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